

Date: Monday, 24/11/2008 9:54:36 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.

Drawing Name : D058-676-201

Job Number : 43715

Estimate Number : 10804

P.O. Number :

Part Number : D058676201

This Issue : 24/11/2008 S.O. No. :

Drawing Number : ECN08-563

Prsht Rev. : NC

Project Number :

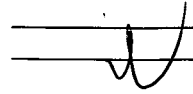
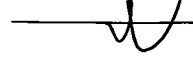
First Issue : / / Type : CROSSTUBES

Drawing Revision :

Previous Run : 43714

Material :

Due Date : 01/12/2008 Qty: 1 Um: Each

Written By : 
 Checked & Approved By : 
 Comment :

Additional Product

Job Number:



DART		TEL: 1-613-632-6336 FAX: 1-613-632-4443	
TRANSPORT CANADA APPROVAL 008-89			
PN	D058-676-201	CHG	CHG001
DESC	Crosstube Aft High	SIC	SR01018SE
LOT	B35535	SIC	
MODEL	OH- 58A+/A/C	SIC	
MADE IN CANADA			

Seq. #: Machine Or Operation:

Description :

1.0 CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: CROSSTUBES RESOURCE 1

Magnabond B# 108966
 exp: 10/2009

REMOVE FROM STOCK:

1 X D058-676-201 B35535 CHG001

REMOVE SUPPORTS D2891-1

RE-INSTALL PER ECN 08-563

PER DSI 9425, WITH MAGNABOND

REMOVE D2856-400-694 AND REPLACE
 WITH D3595-063-395 B 42998

ml 08 11 25 (1)

2.0 D058676201

Crosstube Aft



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Fwd

ml 08 11 25 (1)

3.0 D3595

Rubber Cushion (per sq ft)



Comment: Qty.: 1.0000 sf(s)/Unit Total: 1.0000 sf(s)
 Rubber Cushion (per sq ft)

ml 08 11 25

4.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08 11 26 (1)

Date: Monday, 24/11/2008 9:54:37 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D058-676-201

Job Number: 43715

Part Number: D058676201

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE USING NEW B/N @ CHG002
NEW LABELS AND PAPERWORK REQ'D

Labels checked
Rev B 08/14/27

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/01

Job Completion



mf 08-11-28

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D058-676 REV. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D058-676 REV. 0
REF: FAA STC: SR01018SE

For D058-676-101/-201 crosstubes at CHG 002 or later, the D2856-400-694 abrasion strips have been removed, the D2891-1 supports have been bonded onto the crosstube using Magnabond 6398 and D3595-063-395 Rubber Cushions have been installed underneath the MS21920-20 Clamps. Amend parts list of the IIN-D058-676 Section 5 and ICA-D058-676 Section 32.8 as follows:

REMOVE:


ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
11	2	2	D2856-400-694	ABRASION STRIP

ADD:

ITEM	QTY -101	QTY -201	PART NUMBER	DESCRIPTION
16	4	4	D3595-063-395	RUBBER CUSHION

To prevent the supports from shifting on the D058-676-101/-201 crosstubes at CHG 001, the D2891-1 supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D058-676 for the removal of the crosstubes from the helicopter.
- 2) Remove the qty (2) MS21920-20 clamps from the crosstube that fasten each D2891-1 support to the crosstube.
- 3) Remove the D2856-400-694 abrasion strips from the crosstube per section 32.5 of ICA-D058-676.
- 4) Inspect the crosstube surface underneath each support for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection of ICA-D058-676. Repair damage within acceptable limits per item 5.3.3 of the 300 hour inspection in ICA-D058-676. Touch up finish per item 5.3.9 of the 300 hour inspection.
- 5) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 6) Apply a 0.03" to 0.06" thick layer of Magnabond 6398 underneath each D2891-1 support and re-install the support on the crosstube as shown in Figure 1. Position and secure the D2891-1 supports on the crosstube using MS21920-20 Clamps. Install a D3595-063-395 Rubber cushion underneath each MS21920-20 Clamp. Torque clamps 80-100 in-lb. Let the D058-676-101/-201 crosstube assembly cure as per the Magnabond 6398 instructions before re-installing the crosstube on the aircraft.

A	NEW ISSUE	RF	08.11.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	DS	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9425	SHEET 1 OF 2
APPROVED	DS	TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
DATE	08.11.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W043715

Date: Monday, 24/11/2008 10:00:02 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D058-676-201
Job Number	: 43715		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D058676201
This Issue	: 24/11/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: ECN08-563
First Issue	: 24/11/2008	Project Number	:
Previous Run	: 43714	Drawing Revision	:
		Material	:
Written By	:	Due Date	: 01/12/2008
Checked & Approved By	:	Qty:	1
Comment	:	Um:	Each

Additional Product

Job Number:



REFERENCE ONLY

Seq. #:	Machine Or Operation:	Description :
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1.0	CROSSTUBES	CROSSTUBES RESOURCE 1
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Comment: CROSSTUBES RESOURCE 1

REMOVE FROM STOCK:

1 X D058-676-201 B35535 CHG001

REMOVE SUPPORTS D2891-1

RE-INSTALL PER ECN 08-563

PER DSI 9425, WITH MAGNABOND

REMOVE D2856-400-694 AND REPLACE
WITH D3595-063-395 B

2.0	D058676201	Crosstube Aft
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
 Crosstube Fwd

3.0	D3595	Rubber Cushion (per sq ft)
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Comment: Qty.: 1.0000 sf(s)/Unit Total: 1.0000 sf(s)
 Rubber Cushion (per sq ft)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

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Drawing Name: D058-676-201

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Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE USING NEW B/N @ CHG002
NEW LABELS AND PAPERWORK REQ'D

SP

Labels checked AS.

Rev B

AS 08/11/27 (X)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

